

Worlk Order ID 97354

97354

Feb 2013

Page 1

Friday, February 15, 2013 3:01:05 PM

Item ID: D4438-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Ceiling Protector
 Start Date: 2/15/2013 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 2/22/2013 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: WUF Date: 13-2-19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4438	A

100		0.00							
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100 FLOW WATER JET

Waterjet Memo 0.00 6 0 13-2-21

FLOW CNC Waterjet

1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110

QC Memo 0.00 6 0 13-2-21

Quality Control

120	QC8- Inspect parts - second check	0.00							
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120

QC Memo 0.00 6 0 13-2-22

Quality Control

DAS
15
2-83

13 2 22

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 97354***97354***

Page 2

Friday, February 15, 2013 3:01:05 PM

Item ID: D4438-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Ceiling Protector

Stop ***NS2***

Start Date: 2/15/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/22/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

PP97343

0.00

Packaging

13/2/22 (6)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/2/25

PLB-0222

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Operator									
Material									
Setup									
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Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Friday, February 15, 2013 3:01:04 PM

Page 1

Work Order ID: 97354
Parent Item: D4438-1
Parent Item Name: Ceiling Protector

Start Date: 2/15/2013

Required Date: 2/22/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.10.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	0.0000	12.1	76.421053 80 SF.			Jm13-2-21

124654

124654

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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Supplier									
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FAULT CATEGORY

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DART AEROSPACE LTD		Work Order: 97354
Description: Ceiling Protector		Part Number: D4438-1
Inspection Dwg: D4438 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.79"	±0.030"	18.79"	-		T	Jkmo6
22.03"		22.03"	-		T	
20.06"		20.06"	-		T	
20.86"		20.86"	-		T	
57.46"		57.46"	-		T	
82.37"		82.37"	-		T	
4.85"		4.85"	-		V	Jkmo1
3.11"		3.11"	-		V	
8.09"		8.09"	-		V	Product 2
7.20"		7.20"	-		V	
3.60"		3.60"	-		V	
5.10"		5.10"	-		V	
27.23"		27.23"	-		T	
22.28"		22.28"	-		T	
22.36"		22.36"	-		T	
4.00"		4.00"	-		V	
6.13"		6.13"	-		V	
10.03"		10.03"	-		V	
5.72"		5.72"	-		V	
6.77"		6.77"	-		V	
5.95"		5.95"	-		V	
7.47"		7.47"	-		V	
7.78"	↓	7.78"	-		V	

Measured by: JM
Date: 13.2.21

Audited by: DAS
Date: 13.2.22

Preliminary Approval:
Date:

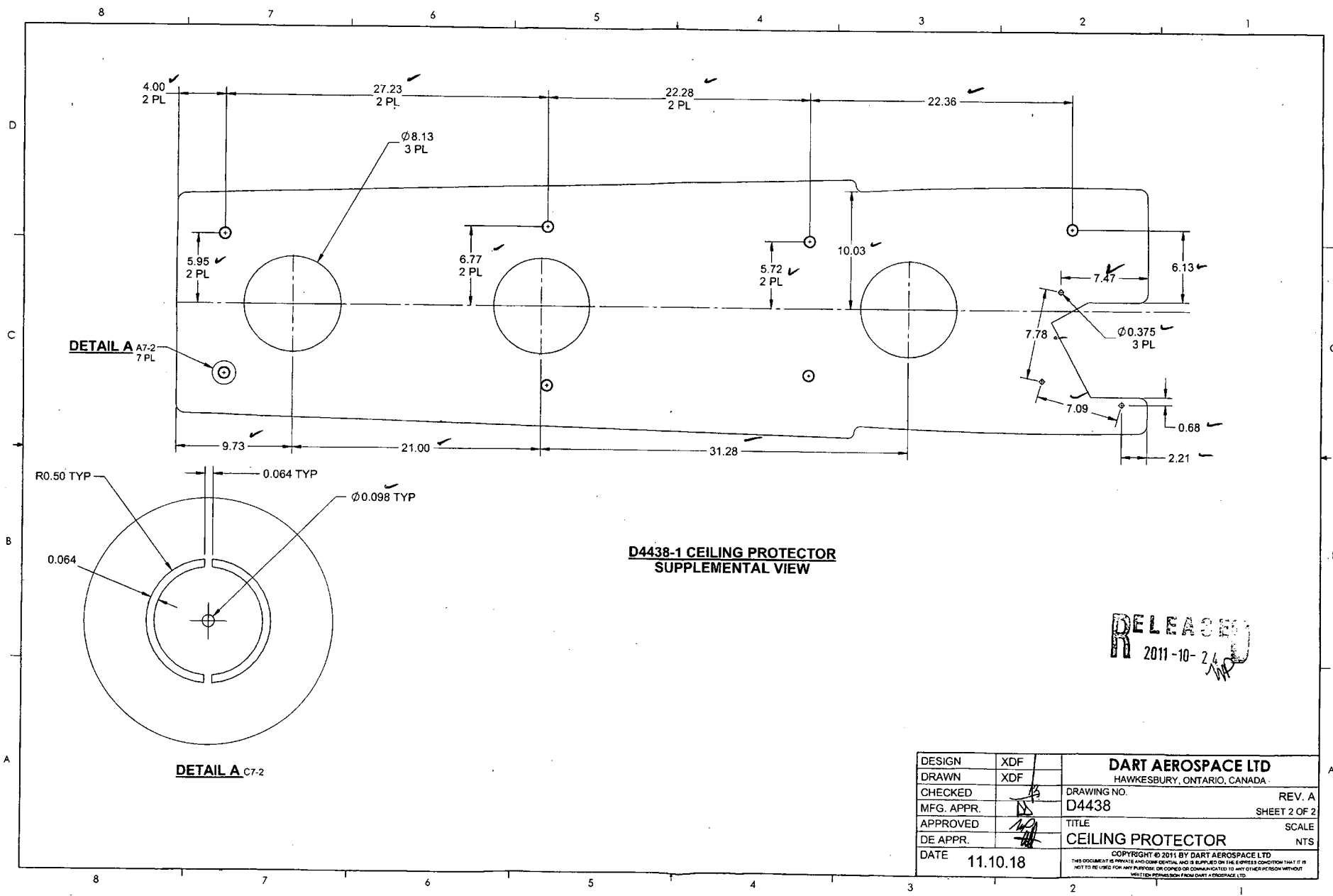
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



A	NEW ISSUE		XDF	11.10.18
REV.		DESCRIPTION	BY	DATE
DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4438 TITLE CEILING PROTECTOR		
DRAWN	XDF			
CHECKED				
MFG. APPR.	<i>[Signature]</i>			REV. A
APPROVED	<i>[Signature]</i>			SHEET 1 OF 2
DE APPR.	<i>[Signature]</i>		SCALE	
DATE	11.10.18		NTS	

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RELEASED
2011-10-24